

Date: Tuesday, 19/08/2008 4:07:10 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TUBE ARM
Job Number :	41508		
Estimate Number :	13515		
P.O. Number :		Part Number :	PB6743001357
This Issue :	19/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.31
First Issue :	/ /	Project Number :	N/A
Previous Run :	41232	Drawing Revision :	B1
Written By :		Material :	
Checked & Approved By :	<u>JLD 08.8.20</u>	Due Date :	18/09/2008
Comment :	Est Rev:A 08-06-26 new issue DD verified by:ec		

20
 12 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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Comment: Qty.: 3.6225 f(s)/Unit Total: 43.4700 f(s)
 6061T6 RD TUBE 1.00 x .065w
 batch: M110 757 (12) MP09116 (3)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length as per dwg -
 2- drill holes as per dwg (DO NOT DRILL THRU)
 3- deburr ✓

SAD 09-02-09 1
 SB 09/02/00 (20)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S026210 (18)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

2192/12 18

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/02/12 18

Job Completion



MF 09-02-12

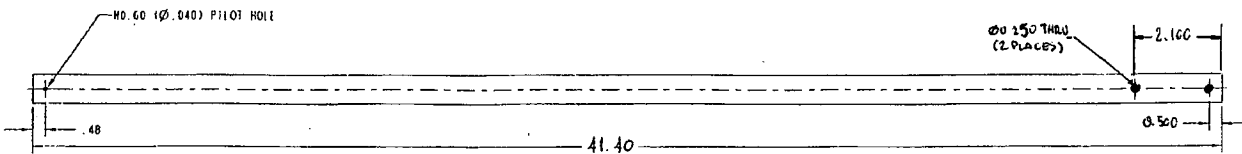
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-357 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 41508		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/2/10	#20	two parts lost from manual machining to QC QC inspector only has 18 but machinest	<i>[Signature]</i>	mat. not pulled but machinest lost did Qty 420 parts.	<i>DF</i> 09/02/17	<i>[Signature]</i> 09/02/19	<i>[Signature]</i> 09/02/19	<i>S</i> 09/02/10
		Says he made 20 R.C. cartridges lost in process. Lack of attention. By QC Inspector + See Job history checked in back	<i>[Signature]</i>	- adjust Qty to 18	<i>DF</i> 09/02/17	<i>[Signature]</i> 09/02/19	<i>[Signature]</i> 09/02/19	<i>S</i> 09/02/10

NOTE: Date & initial all entries

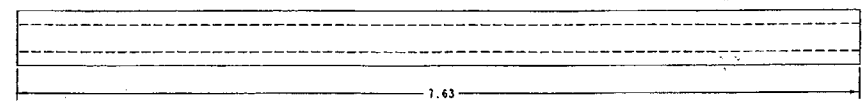


MATL: 1.00 O/D X .065 WALL, 6061-T6
 HW-1-700/6
 SCALE 0.500

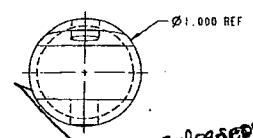
① -357 TUBE ARM (SAME, EXCEPT AS SHOWN) ☒ ☐
 (CANADIAN VERSION)

Jan 15 1977

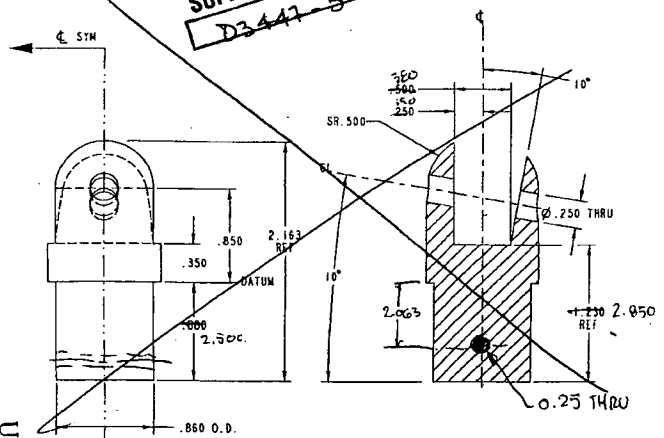
RELEASED
 7/16/81



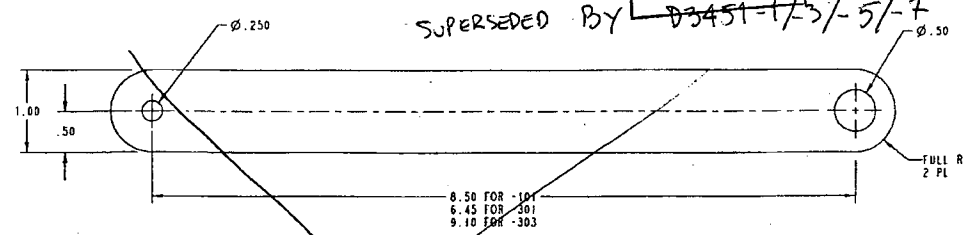
① -103 TUBE HANDLE ☒ ☐
 MATL: .50 O/D X .125 WALL, 6061-T6, 00-A-200/8
 SCALE 2.000



SUPERCEDED BY
 D3447-5



-50 CLEVIS ☒ ☐
 MATL: 1.00 RND, 6061-T6, 00-A-200/8
 SCALE 2.000



SUPERCEDED BY
 D3451-1/3/5/7

④ -101 TUBE HANDLE ARM (SHOWN) ☒ ☐
 MATL: .125 THK, 6061-T6, 00-A-200/8
 SCALE 1.000
 ② -301 TUBE HANDLE ARM (SAME, EXCEPT AS SHOWN) ☒ ☐
 ② -303 TUBE HANDLE ARM (SAME, EXCEPT AS SHOWN) ☒ ☐

PREMIER AVIATION, INC.
 2000 Aviation Parkway, Grand Prairie, Texas 75052
 SIZE CODE 12511 NO. DWG NO. 867-43001
 SCALE: (N) SECRET 31 of 45

ORIGINAL

NO 41508
 WORK ORDER
 WITHIN 100
 SUBJECT TO
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

Date: Tuesday, 10/02/2009 1:18:51 PM

User: Melanie Fauteux

JOB HISTORY : DETAIL

Job Number	: 41508	Customer	: Dart Helicopters Services
Estimate Number	: 13515	DWG Name	: TUBE ARM
Purchase Order #	:	Part Number	: PB6743001357
Complete Date	: / / : : AM	DWG Number	: B6743001 P.31
		Rev.	: B1

DUE DATE	ORDERED	DELIVERED
18/09/2008	12	0

2.0 SMALL FAB 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
09/02/2009	DROU02: Drouin, Steven	Run	0.000	1.70	\$31.14	1.70	75.67
10/02/2009	FOUR01: Fournier, Sebastien	Run	20.000	1.63	\$28.77	1.63	69.91

Subtotal: QTD: 20 CTD: 0 3.33 \$205.49

	TIME	COST	REFERENCE ONLY
Machine Time:	3.33	\$145.58	
Labor:	3.33	\$59.91	
Sub-contract (external Op.):		\$0.00	
INVENTORY ITEM:		\$0.00	
SUB-COMPONENT (SUB-JOB):		\$0.00	
Total:		\$205.49	

COST PER UNIT: \$205.49